



Dart Aerospace Ltd. SEP 11 2018
1270 Aberdeen St
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Canada
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D407-836-015
Job Sheet 182781



Part No: D407-836-015

Job Qty: 2 ea

Part Name: Crosstube Antenna Mount 407 Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/31/18

Job Tracking No:

Due Date: 9/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 7 IPP REV:A 13.07.18 AS PER ECN13-561 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	9/20/18	9/20/18	0.00	0.00	Start Up Stores/Pkg-2		SEP 12 2018
110	Packaging	2 pcs	9/20/18	9/20/18	0.00	0.00	Packaging1-4		SEP 12 2018
120	QC	2 pcs	9/20/18	9/20/18	0.00	0.00	QC4		DAS 69
125	DC	2 pcs	9/20/18	9/20/18	0.00	0.00	DC		DAS 69
130	Packaging	2 pcs	9/20/18	9/20/18	0.00	0.00	Packaging3-2		SEP 9-89
140	QC21-FG	2 Ea	9/20/18	9/20/18	0.00	0.00	QC21		SEP 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-11A	Bolt	4 Ea (2 ea)	90-Start up Operation	507093
AN4-16A	Bolt	4 Ea (2 ea)	90-Start up Operation	5099494
D2732-030	Rubber Cushion - 3"	4 Ea (2 ea)	90-Start up Operation	509253
D4853-5	Top Bracket	2 Ea (1 ea)	90-Start up Operation	5109072
D4854-5	Lower Bracket	2 Ea (1 ea)	90-Start up Operation	5032420
D4855-1	Antenna Bracket	2 Ea (1 ea)	90-Start up Operation	5042386
MS21042L4	Nut	8 Ea (4 ea)	90-Start up Operation	5081363x4
NAS1149D0432J	Washer	16 Ea (8 ea)	90-Start up Operation	50870x9

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-11A	4	284	0
	AN4-16A	4	518	0
	D2732-030	4	153	0
	D4853-5	2	9	0
	D4854-5	2	9	0
	D4855-1	2	8	0
	MS21042L4	8	4,810	0
	NAS1149D0432J	16	1,092	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description Wor _____		DISPOSITION Skid-tube ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		AGAINST DEPARTMENT/PROCESS Engineering ☐ Quality ☐ Other ☐ MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
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Part: D407-886-015
 Job No: 182781
 Serial No/Batch: S109663
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____

 Date: 09/12/18

DART AEROSPACE
 Container No: S109663
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 Hamlet, ON K8A 1K7
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 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature, ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
OTHER : _____			

☐ i/Surge ☐ ram ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
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5. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -111	Part Number	Description
X					D206-836-011	CROSSTUBE ANTENNA MOUNT KIT 206A/B AND 206L FWD (P162-206)
	X				D206-836-013	CROSSTUBE ANTENNA MOUNT KIT 206L AFT (P162-206L)
		X			D407-836-015	CROSSTUBE ANTENNA MOUNT KIT 407 FWD (P162-407F)
			X		D407-836-017	CROSSTUBE ANTENNA MOUNT KIT 407 AFT (P162-407A)
				X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
			1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
1				1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
		1		1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1			1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
			1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
1				1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
		1		1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1			1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	1	1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	2	2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	2	2	2	AN4-16A	BOLT
2	2	2	2	2	AN4-11A	BOLT
8	8	8	8	8	NAS1149D0432J	WASHER
4	4	4	4	4	MS21042L4	LOCKNUT

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Revision: A

Date: 13.05.15

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Description: CROSSTUBE ANTENNA MOUNT, 407 FWD

H:\Forms\Engineer\Approved Eng Online\CHGREC revB